

- 12 -

**CLAIMS**

1. A method for producing shoes, characterized in that it includes the following steps:
- 5    -    obtaining of an assembly (T,T1), formed by a shoe upper (2) and an elastic element (6,60), fastened to the shoe upper at least along the sections facing the lower edges of the shoe upper central-fore area;
  - 10    -    obtaining of a sole (5), whose size corresponds to the size of said shoe upper, and whose upper surface has fastening means (50), engaging at least the central-fore portion thereof, so that the upper surface defines at least one fore fastening area (Z) and at least one rear fastening area (Z1);
  - 15    -    mutual fastening of the fore fastening area (Z) of the sole (5) to a corresponding fore portion of said assembly, and of the rear fastening area (Z1) of the sole (5) to a corresponding rear portion of said assembly, to obtain a sole - assembly group (W,W1);
  - 20    -    introduction of a user's foot into the sole - assembly group (W,W1), with a subsequent transversal stretching of said elastic element (60) and adaptation of said shoe upper (2) to the foot conformation;
  - 25    -    pre-fastening of said elastic element to the fastening means (50), by pressure of the user's foot onto said elastic element;
  - removal of the user's foot from the sole - assembly group (W,W1);

- 13 -

- joining of the sole - assembly group (W,W1), to obtain a shoe.

2. A method according to claim 1, characterized in that  
5 said assembly (T,T1) is fitted on a corresponding last before being fastened to said sole (5), and in that after said sole - assembly group (W,W1) has been obtained, the assembly (t,T1) is removed from the last.

10 3. A method according to claim 1, characterized in that said group (W1) is obtained by the following steps:

- placing said elastic element onto the face of a corresponding last;
- fitting the shoe upper (2) onto the last;
- 15 - fastening said elastic element at least to the opposite sections of the lower edges of the shoe upper central-fore area;

and in that after said group (W1) has been obtained, it is removed from the last.

20

4. A method according to claim 2, characterized in that, before fitting of the group (W) onto the last, a heel-  
insole is placed on the rear portion of the surface of the last, and subsequently, the heel-insole is fastened  
25 to the shoe upper.

5. A method according to claim 2, characterized in that, before fitting of the group (W) onto the last, an insole is placed on the surface of the last, and subsequently,

- 14 -

the heel area and the toe area of the insole are fastened to the shoe upper.

- 5 6. A method according to claim 1 or 3, characterized in that said elastic element is situated in the central-fore part of a corresponding insole (S), with the latter being fastened to the shoe upper lower edges.
- 10 7. A method according to claim 6, characterized in that said elastic element has the shape similar to the central fore portion of the insole (S) and is inscribed therein.
- 15 8. A method according to claim 1, characterized in that at least said fore fastening area (Z) is external to the fastening means (50).
- 20 9. A method according to claim 1 or 3 or 6, characterized in that said opposite edges of the shoe upper (2) are fleshed before said elastic element is fastened thereto.
- 25 10. A method according to claim 3, in which said shoe upper (2) is formed by an external layer (25) and an internal layer (26), or lining, characterized in that before the shoe upper (2) is fitted onto the last, the terminal portions (250,260) of said external layer (25) and said lining (26), respectively, are separated and a stitching (U) is made at a distance ("d") from said external layer (25) and said lining (26).

- 15 -

11. A method according to claim 1, characterized in that a protective sheet touching the upper part of the fastening means (50) is removed before said elastic element is pre-fastened to the fastening means (50).

5

12. A method according to claim 1 or 3 or 6, characterized in that said elastic element is fastened to said lower edges of the shoe upper (2) by stitching.

10 13. A method according to claim 1 or 3 or 6, characterized in that said elastic element is fastened to said lower edges of the shoe upper (2) by the application of adhesive means onto the surface of at least the edges of the shoe upper (2) aimed at being joined to a  
15 corresponding portion of said elastic element.

14. A method according to claim 10, characterized in that said insole (S), together with its elastic element (60) is fastened to said terminal portion of said lining (26)  
20 by stitching.

15. A method according to claim 10, characterized in that said insole (S), together with its elastic element (60) is fastened to said terminal portion of said lining (26)  
25 by adhesive means.

16. A method according to claim 10, characterized in that said elastic element (6) is fastened to said terminal portion (260) of said lining (26) by stitching.

30

- 16 -

17. A method according to claim 10, characterized in that said elastic element (6) is fastened to said terminal portion (260) of said lining (26) by adhesive means.
- 5 18. A method according to claim 1, characterized in that the sole - assembly group (W,W1) is joined by heating said group and pressing the assembly (W,W1) against the sole (5).
- 10 19. A method according to claim 10, characterized in that the terminal portion (250) of said external layer (25) is joined to said terminal portion (260) of said lining (26) before the shoe (9,900) is obtained.
- 15 20. A method according to claim 1, characterized in that after the shoe (9,900) has been obtained, a finishing insole (90) is placed thereinside.
21. A shoe characterized in that it includes:
- 20 an assembly (W,W1) formed by a shoe upper (2) and an elastic element fastened to the latter at least along the lower opposite edges of the central fore area of the shoe upper (2);
- a sole (5), having fastening means (50);
- 25 two points for mutual fastening of said assembly and sole, one of which being defined between the rear portion of the sole (5) and a corresponding rear portion of said assembly, and the other point being defined between the fore portion of said sole (5) and a corresponding fore
- 30 portion of said assembly, with said elastic element being

- 17 -

aimed at stretching crosswise, after the user has introduced his foot into said assembly, and at being removably fastened to said fastening means (50), due to a pressure between said sole and assembly performed by said  
5 foot.

22. A shoe according to claim 21, characterized in that said elastic element is situated in the central portion of a corresponding insole (S), the latter being fastened  
10 to the lower edged of said shoe upper (2).

23. A shoe according to claim 21, characterized in that the profile of said elastic element is similar to the profile of the central fore portion of the corresponding  
15 sole (5), but its dimensions are slightly smaller with respect to the sole.

24. A shoe according to claim 21, characterized in that the profile of said elastic element is similar to the profile of the sole of the corresponding sole (5), but its dimensions are slightly smaller with respect to said  
20 sole.

25. A shoe according to claim 22 or 23 or 24, characterized in that said elastic element is an elastic strip.

26. A shoe according to claim 22 or 23 or 24, characterized in that said elastic element is a plurality  
30 of elastic strips.

- 18 -

27. A shoe according to claim 21, characterized in that it has a sheet situated in contact with the upper surface of the fastening means (50), aimed at preventing the latter from fastening to said elastic element before the shoe is obtained, and removable after the shoe conformation has been defined.

28. A shoe according to claim 21, characterized in that said fastening means include velcro® of heat-weldable material.

29. A shoe according to claim 21, characterized in that said fastening means include adhesive means.

15